

Work Order ID 164345

164345

Page 1

Wednesday, July 19, 2017 11:09:56 AM

Item ID: D3393-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Battery Lock Casing
 Start Date: 7/27/2017 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 8/4/2017 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-29 Date: JUL 19 2017 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3393	Rev A

100	BAND SAW	0.00				8x	Ø		<u>mm</u> 2017/08/01
100									
Bandsaw	Memo	0.02							
Jeaspa Bandsaw	Cut blank: 1.500" x 1.500" x 3.125" long								
110	HAAS CNC VERTICAL MACHINING #1	1.12				8x	Ø		<u>mm</u> 2017/08/02
110									
HAAS 1	Memo	1.80							
HAAS CNC vertical machine #1	Machine D3393-1 as per Folio FA510 and Dwg D3393Identify as D3393-1								
	Deburr								
120	QC2- Inspect parts off machine FAI/FAIB	0.00				8x	Ø		<u>mm</u> 2017/08/02
120									
QC	Memo	0.16							
Quality Control									

PTIO.

DQA:

Date:

Sept 21 2017

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

SEP 13 2017

Work Order update only ☐

Work Order: <u>164345</u> Part No. <u>D3393-1</u> NCR No. <u>17-6613</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date: <u>17-08-03</u>	Step #: <u>110</u>	QTY Effective: <u>①</u>	MRB (QSI042) Approval DAS 9 9-89 17-08-03																																																																	
Description Work Order Deviation		Disposition																																																																		
Dimension .100" $\pm .000$ is .078" R.C. setup. Part was not sitting straight in vise		scrap destroy no replace		Completed By DAS 45 9-89 17-08-03 Lead hand / Supervisor Approval Verification DAS 08 9-89 17-08-03 QC / QA Coordinator Approval DAS 9 9-89 17-08-03																																																																
Root Cause <table style="width:100%;"> <tr><td>Environment ☐</td><td>No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☒</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☒	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%;"> <tr> <td>Pressure/Forced ☐</td> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☒</td> </tr> <tr> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>			Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☒	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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Page 2

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 Start Date: 7/27/2017 Start Qty: 8.00 ***8*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.16				7	1		DAS 45 9-89 2017-03
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.71				(x7) 			201708104 BFB
150 *150* Powdercoat Powder Coating	Fire Red(Ref:4.3.5.10) per QSI005 4.3 m 129223 Memo START TIME: <u>2:30</u> FINISH TIME: <u>3:00</u>	0.00 0.50				7 	17.09-5.		858 0-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.16				7x			17/09/07 DAS 38 9-88
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: ST501 Memo	0.00 2.40				7		SEP 07 2017	17/09/07 DAS 6 89
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.08						17/9/8	17/9/8 DAS 21 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, July 19, 2017 11:09:59 AM

Page 1

Work Order ID: 164345

164345

Parent Item: D3393-1

D3393-1

Parent Item Name: Battery Lock Casing

Start Date: 7/27/2017

Required Date: 8/4/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A05.02.18New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.50 0		Purchased	No			100	f	6.0000	0.2708	2.280421			

M6061T6B1 500X01 500

6061-T6 Bar 1.50 x 1.50

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT004	6	
→ M135377	6	

DAS
45
9-89
2.13
2017/08/01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

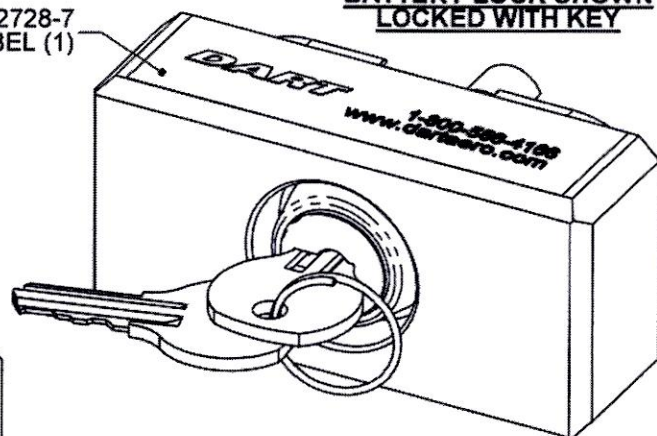
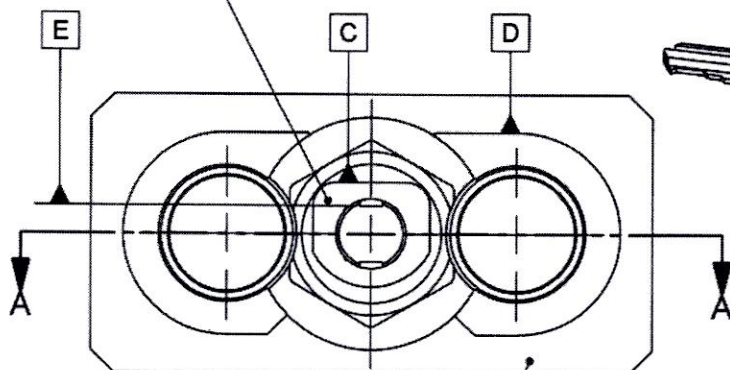
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Misidentified ☐	Past Due ☐																																																																

DART

DESIGN 43	DRAWN BY 43	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 77	APPROVED [Signature]	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
[Signature]

05/03/09

**BATTERY LOCK SHOWN
LOCKED WITH KEY**D2728-7
LABEL (1)POSITION FACE **C** OF D3369-5
PARALLEL TO FACES **D** AND **E**
AS SHOWND3373-1
CAM LOCK
ASSEMBLY (1)D3393-1
CASING (1) $\varnothing 5/16"$ WC S/S
WASHER (2)

D3369-5 SPACER (1)

PRESS FIT POLYETHYLENE CAP (2) Δ
AND APPLY KRAZY GLUED3393-3 CAM
LOCK SHAFT (1) $0.09^{+0.03}_{-0.01}$ (2 PLACES)TACK WELD
D3393-3 TO D3369-5**SECTION A-A****D3393-041 BATTERY LOCK ASSEMBLY****NOTES:**

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

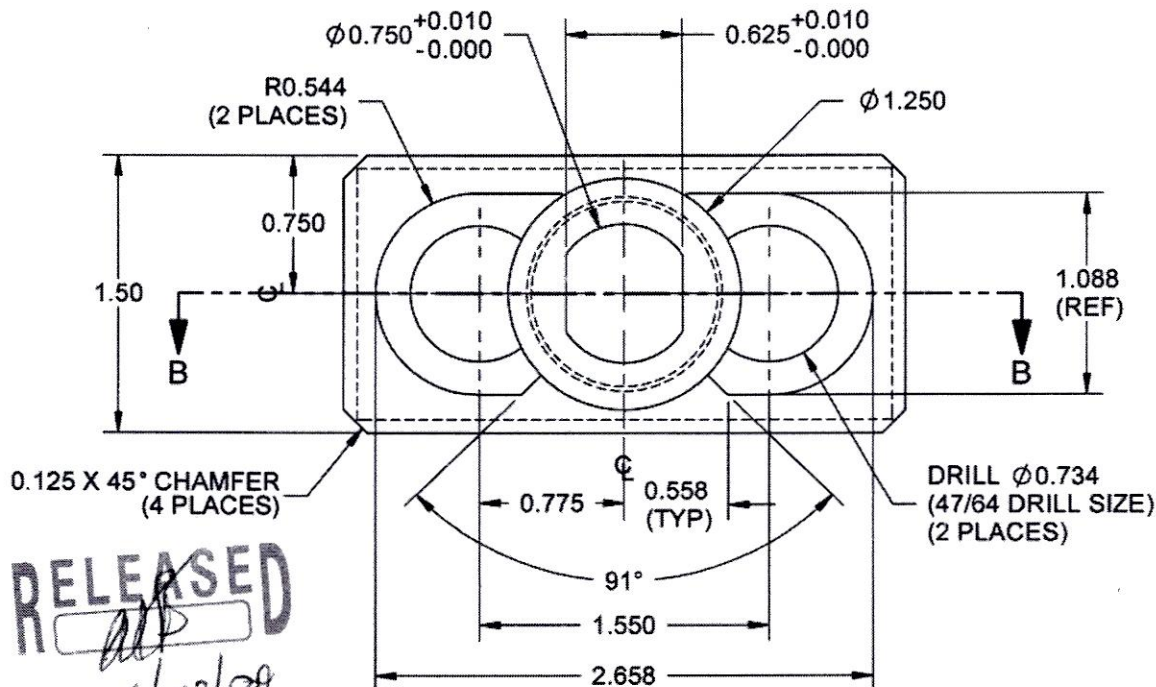
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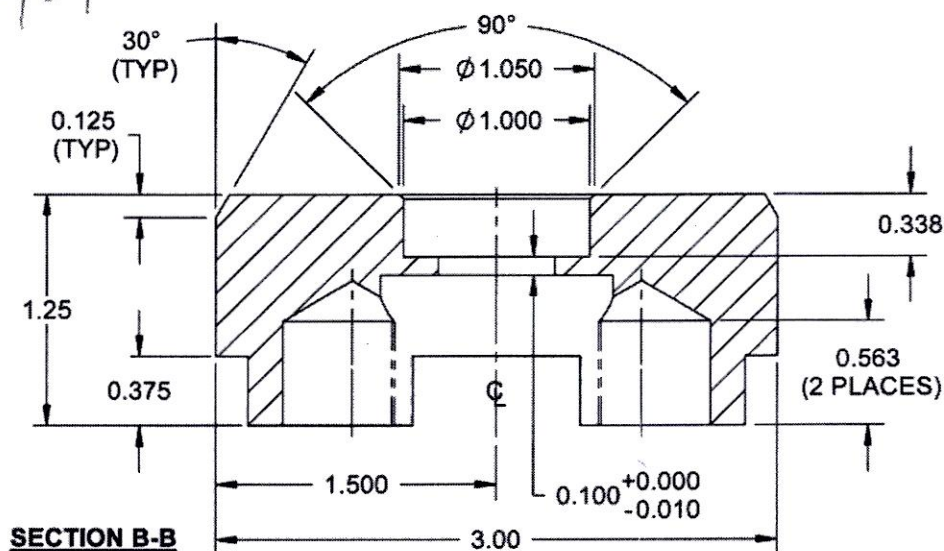
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 169345 M25
1903/09



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED [Signature]	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 1:1



RELEASED
05/03/09



SECTION B-B

D3393-1 CASING

NOTES:

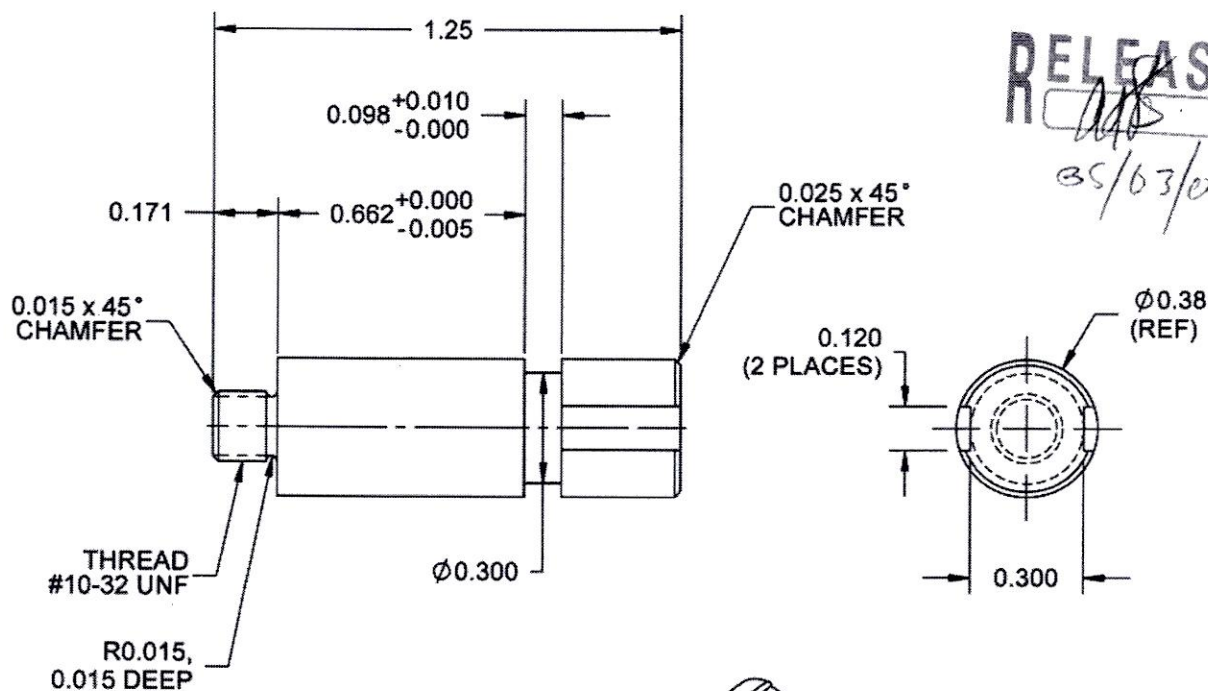
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order: 164345
Description: Battery Lock Casing		Part Number: D3393-1
Inspection Dwg: D3393	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+0.010/-0.000	.751 Ø	✓		Vern MLO6	
0.625	+0.010/-0.000	.629	✓		Vern MLO6	
Ø1.250	+/-0.010	1.248	✓		Vern MLO6	
1.088	+/-0.010	1.087	✓		Vern MLO6	
Ø0.734	+/-0.010	.743 Ø	✓		Vern MLO6	
2.658	+/-0.010	2.658	✓		Vern MLO6	
1.550	+/-0.010	1.557	✓			
0.125 x 45°	+/-0.010 x 0.5°	.127 x 45°	✓		Vern MLO6	
1.50	+/-0.030	1.490	✓		Vern MLO6	
0.750	+/-0.010	.754	✓		Vern MLO6	
Ø1.050	+/-0.010	1.044 Ø	✓		Vern MLO6	
Ø1.000	+/-0.010	.995/.999	✓		Vern MLO6	
0.338	+/-0.010	.336	✓		Vern MLO6	
0.563	+/-0.010	.555	✓			
0.100	+0.000/-0.010	.097	✓		high gauge	
3.00	+/-0.030	3.002	✓		Vern MLO6	
1.500	+/-0.010	1.502	✓		Vern MLO6	
0.375	+/-0.010	.376	✓		Vern MLO6	
1.25	+/-0.030	1.243	✓		Vern MLO6	
0.125	+/-0.010	.130	✓		Vern MLO6	
30°	0.5°	30°	✓			

Measured by: M.H.F.	Audited by: DAS 45	Prototype Approval:	N/A
Date: 2017/08/02	Date: 2017-8-3	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	
B	08.11.28	Tolerances revised	KJ/EC	